

# Work Order ID 62250

Thursday, September 23, 2010 8:03:32 AM

Page 1

Item ID: D4171-1

Revision ID:

Item Name: Bushing

Start Date: 9/23/2010 Start Qty: 10.00

Required Date: 9/30/2010 Req'd Qty: 10.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date: 09-23

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4171

A

100

0.00



Doosan

Doosan Lathe

DOOSAN LATHE

Memo

1-Turn as per Dwg & Folio FA963  
2-Deburr

0.00

10.10.13

3

110

0.00



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

10.10.13

3

140

0.00



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

10.10.13

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 62250**

Thursday, September 23, 2010 8:03:32 AM



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Item ID: D4171-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bushing

Start Date: 9/23/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 9/30/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

200

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

*Ch-4/10/13*

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*10/10/13**W 10-10-13*

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, September 23, 2010 8:03:37 AM

Page 1

Work Order ID: 62250

Parent Item: D4171-1

Parent Item Name: Bushing



Start Date: 9/23/2010

Required Date: 9/30/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A NEW ISSUE 10-09-22 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R1.000 		Purchased	No			100	f	4.0560	0.08	0.842105			
303 Round Bar 1.00													

*10.10.13*

Location	Loc Qty	Loc Code
MAT028	4.056	
113325	4.056	

227

*113774*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_


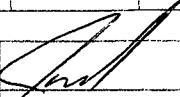
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries


DART AEROSPACE LTD		Work Order: 62250
Description: TBUSHING		Part Number: D4171-1
Inspection Dwg:	Rev: A	Page 1 of 1

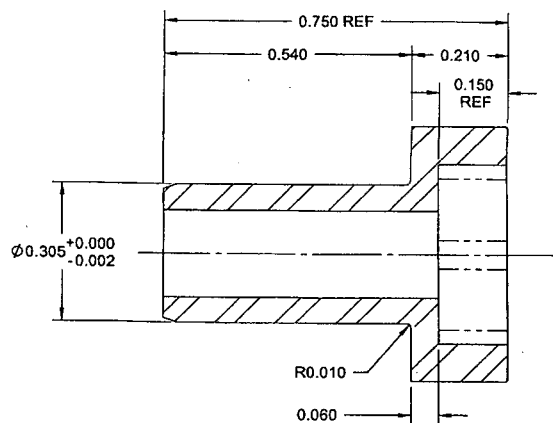
### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.750	+/- .010	.749				
.540	+/- .010	.540				
.210	+/- .010	.210				
.150	+/- .010	.150				
.305	+/- .002	.305				
R.010	+/- .010	R.005				
.060	+/- .010	.060				
60°	+/- 1/2°	60°				
.395	+/- .005	.396				
.563	+/- .015	.560				
45°	+/- 1/2°	45°				
R.060	+/- .010	R.06				
R.010	+/- .010	R.010				
.023	+/- .010	.023				
.023 x 20°	+/- .010	.023 x 20°				
.191	+/- .005	.194				

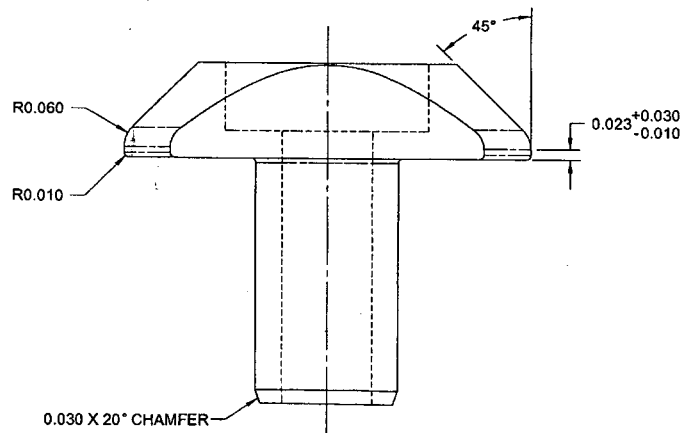
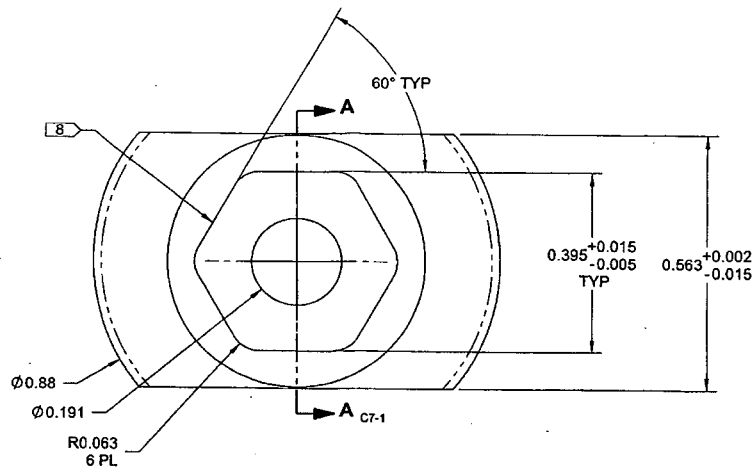
Measured by: 	Audited by: 	Preliminary Approval:
Date: 10.10.13	Date: 10.10.13	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

 10.04.15



C4-1 **SECTION A-A**



**D4171-1 BUSHING**

**NOTES:**

- 1) MATERIAL: AISI 303 STAINLESS STEEL ROUND BAR PER ASTM A582  
REF DART SPEC M303R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs
- 8) HEXAGON/HOLE MUST ALLOW INSERTION OF AN3 BOLT.

SHOP COPY  
RETURNED  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 62250  
BF10-9-27

**RELEASED**  
2010-09-15  
JM

REV.	NEW ISSUE	DESCRIPTION	CP	10.08.26
DESIGN			BY	DATE
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	10.08.26			

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4171** REV. A  
SHEET 1 OF 1  
TITLE **BUSHING** SCALE NTS

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